DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-015272
Date Inspected: 22-Jun-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	N/A		**CWI Present:**	☐ Yes ☑ No	
Inspected CWI report:	☐ Yes	☑ No ☐ N/A	**Rod Oven in Use:**	☐ Yes ☐ No	☑ N/A
Electrode to specification:	☐ Yes	☐ No ☑ N/A	**Weld Procedures Followed:**	☐ Yes ☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No ☑ N/A	**Verified Joint Fit-up:**	☐ Yes ☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No ☑ N/A	**Approved WPS:**	☐ Yes ☐ No	☑ N/A
			Delayed / Cancelled:	☐ Yes ☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Components

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.
Orthotropic Box Girder (OBG) Trial Assembly Areas
Segment 11AE (Green Tag DCP)
This QA Inspector performed Green Tag DCP along with Mr. Math for the Segment 11AE from Panel Point (PP) 94.75 to PP 97.75.
Plumpness and Flatness measurement for Deck Panel to Deck Panel Diaphragm at PP 95, PP 96 and PP 97 from East and West Side of the Diaphragm.
Flatness measurement for Floor Beam at PP 95, PP 96 and PP 97 Cross Beam and Counter Weight Side.
Skin Flatness for Side Panel to Corner Assembly Bike Path Side and Cross Beam side from PP 94.75 to PP 97.75.
Skin Flatness for Deck Panel to Corner Assembly Bike Path Side and Cross Beam side from PP 94.75 to PP 97.75.
The measured readings were recorded on Dimension Control Forms and submitted to the Task Leader and Engineer for review.
Segment 7DE (FL3 to Bottom Plate)
This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts connecting FL3 flange to the Bottom Plate at Panel Point (PP) 56, PP 57 and PP 58 for Segment 7DE. Inspected bolts tension on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00396 Dated March 22, 2010.
Bolt sizes used were M24 x 60 RC Set# DHGM240014 and final torque required was 567 N-m,
Bolt sizes used were M24 x 65 RC Set# DHGM240013 and final torque required was 540 N-m
Manual Torque wrench was been used with Sr. No. XO2-747.

Segment 7DE (FL3 to Bottom Plate)
This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts connecting Bottom Panel to the Bottom Plate at Panel Point (PP) 56, PP 57 and PP 58 for Segment 7DE. Inspected bolts tension on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00398 Dated March 22, 2010.

Bolt sizes used were M24 x 70 RC Set# DHGM240075 and final torque required was 1480 N-m
Manual Torque wrench was been used with Sr. No. XO2-747.
Segment 8AE to 8BE (T-Ribs clips)
This Quality Assurance (QA) Inspector witnessed final tension verification for clips connecting FL 2-2 to the Bottom Plate Y-ribs at Panel Point (PP) 64,65 and 67, 68. Inspected bolts tension on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification.
Bolt sizes used were M22 x 80 RC Set# DHGM240091 and final torque required was 460 N-m,
Segment 11AE (Cope Holes)
This QA Inspector performed Dimension Control Inspection for the Floor Beam to Bottom Panel Cope Holes and Floor Beam to Side Panel Cope Hole at Work Point E4 and E3 at Panel Point (PP) 95, PP 96 and PP 97 for Segment 11AE the Inspection was performed against the ABF Inspection Report No. CWAHIR-11AE-01 Dated June 21, 2010. The measured readings were recorded in the Dimension Control Form (DCP) and submitted to the Task Leader and Engineer for review.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:
No relevant Conversation.
Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer